

Work Order ID 145246-2 *Sp16-1* *145246*

Thursday, May 05, 2016 9:21:26 AM

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Item ID: D2230-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Mounting Lug
 Start Date: 5/6/2016 Start Qty: 100.00 *100* Cust Item ID:
 Required Date: 5/20/2016 Req'd Qty: 100.00 *100* 504 Customer:
 Reference:

Approvals: Process Plan: MLS Date: MAY 05 2016 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start *NR1*
 Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2230	Rev G								DAS
110	Outsource process - Machining	0.00							13
110	HAAS CNC VERTICAL MACHINING #1								9-89
Outsource5	Memo	0.00							
Outsource process - Machining	Issue P/O to Metec: <u>32323</u>								
	Machine as per dwg								
	C of C is required								
120	Receive & Inspect for Damage & Mat'l Certs	0.00							
120									
Packaging	Memo	2.00							
Packaging	Ensure C of C is attach								
130	QC6- Inspect dimensions to drawing	0.00							
130									
QC	Memo	0.00							
Quality Control									

100 MAY 10 2016

50x Sp16-6-1

(50) DAS 38 JUN 27 2016

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Item ID: D2230-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Mounting Lug
 Start Date: 5/6/2016 Start Qty: 100.00 ***100*** Cust Item ID:
 Required Date: 5/20/2016 Req'd Qty: 100.00 ***100*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo <i>N/A</i> <i>38 9-89</i>	0.00 0.00							
150 *150* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo <i>N/A</i> <i>38 9-89</i> <i>Water</i>	0.00 1.00							
160 *160* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo <i>N/A</i> START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____ <i>38 9-89</i>	0.00 0.00							

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Item ID: D2230-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Mounting Lug

Start Date: 5/6/2016 Start Qty: 100.00

100

Cust Item ID:

Required Date: 5/20/2016 Req'd Qty: 100.00

100

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC3- Inspect Part Finish	0.00							DAS 38 9-88
170									
QC	Memo	1.00							
Quality Control									JUN 27 2016
180	Identify as per dwg & Stock Location: <u>SK25A</u>	0.00							
180									
Packaging	Memo	1.00							
Packaging									JUN 28 2016
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	10.00							
Quality Control									16/6/28 <u>JS</u>

JS 6/28/16

Picklist Print

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Work Order ID: 145246

145246

Parent Item: D2230-1

D2230-1

Parent Item Name: Mounting Lug

Start Date: 5/6/2016

Required Date: 5/20/2016

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP D00.11.01 Added inspection level 8, and removed P/O for powder coatEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2230-1P		Purchased	No				Each	0.0000		100			
D2230-1P									**				
Lug													
D2423		Manufactured	No			110	f	272.8334	0.0683	7.189474			
D2423									**				
Lug Extrusion													

50x SP16-6-1

MAY 10 2016

DAS
13
9-82

Location

Loc Qty

Loc Code

Metec

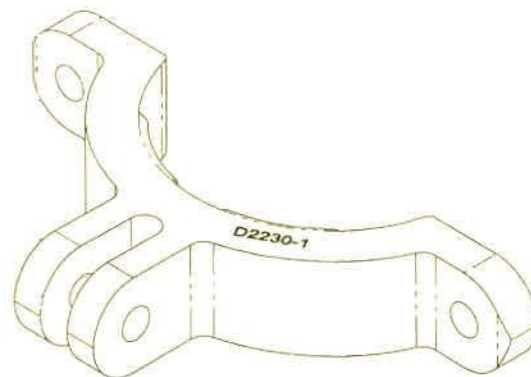
272.8334457

127892

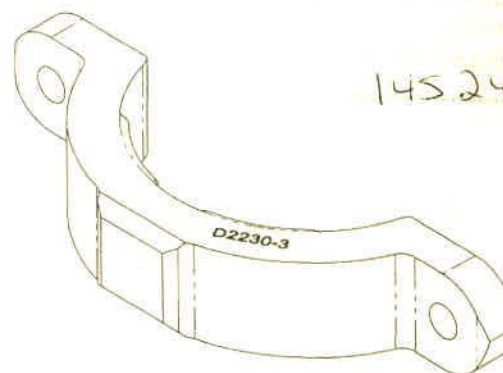
38.9964647

131451

233.836981



D2230-1 MOUNTING LUG



D2230-3 MOUNTING LUG

RELEASED
16-05-05



NOTES

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ± 0.005
- 7) WEIGHT: -1: 0.15 lbs
-3: 0.14 lbs

REV	DESCRIPTION	BY	DATE
G	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A & B-B FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION	AJS	09 01 16
F	REDESIGN: R1 200 WAS 1 100	CP	99 12 13
E	RE-DESIGN	BW	95 01 04
D	RE-DESIGN	BW	95 01 04
C	RE-DESIGN	BW	94 03 30
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV G
MFG APPR		D2230	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR		MOUNTING LUG	NTS
DATE	09 01 16	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 21245
Date: May 18, 2016
Page: 1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 32323	Sold By: VanDenYssel, David
Shipped By: your truck	Ship Date: May 18, 2016

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2230-1 Mounting Lug, as per drawing D2230 Rev.G Alodine and Paint as per QSI 005	Each	100 1	50	
D2230-3 Mounting Lug, as per drawing D2230 Rev.G Alodine and Paint as per QSI 005	Each	80 1	40	
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.				
Received by _____		Thank you for your order!		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO32323

Purchase Order Date 5/10/2016

PO Print Date 5/10/2016

Page Number 1 of 2

Order From :

METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, ON K0B 1R0
CA

VC-MET003

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED

Contact Name

Vendor Phone 613 678 3957

Ship To Contact

Ship To Phone

Ship Via: Dart Truck

Ship Acct:

Buyer

Customer POID

Customer Tax #

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 10

CAD

Destination-Collect

MAY 10 2016

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D2230-1P AS PER DWG D2230 REV. G B145246 ALODINE AND PAINT AS PER QSI 005	Lug	5/20/2016 Yes 5/20/2016		100.00 Each	\$16.10	\$1,610.00
Line Total:							\$1,610.00
2	D2230-3P AS PER DWG D2230 REV. G B145363 ALODINE AND PAINT AS PER QSI 005	Lug	5/20/2016 Yes 5/20/2016	FN	80.00 Each	\$13.80	\$1,104.00
Line Total:							\$1,104.00

Note:

5/10/2016



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
50	D2230-1	Lug Paint Batch# 20393	32323
40	D2230-3	Lug Paint Batch# 20393	32323

MATERIAL: supplied by DART B131451

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Jan Norris

Vankleek Hill, May 18, 2016